

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009293**Date Inspected:** 26-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xian Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & TOWER Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Sandeep Kumar was present during the times noted above for observations relative to the work being performed.

BAY 2

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #019 located on Floor Beam FB3012 – 001. Welder is identified as 045203. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #016 located on Floor Beam FB3026 – 001. Welder is identified as 215676. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #043 located on Floor Beam FB3093 – 001. Welder is identified as 062438. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

BAY 3

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #012 located on Longitudinal Diaphragm LD002 – 047. Welder is identified as 206623. ZPMC QC is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – P4 – F.

FCAW process welding of weld joint #057 located on X-37 stiffener CA080. Welder is identified as 044790. ZPMC QC is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4b – F.

FCAW process welding of weld joint #036 located on CSD3 – PP101. Welder is identified as 051356. ZPMC QC is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #048 located on X-37 stiffener CA088. Welder is identified as 044790. ZPMC QC is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

FCAW process welding of weld joint #099 located on CSD6 – PP102. Welder is identified as 051356. ZPMC QC is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

BAY 5

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #002 located on Traveler Rail 11TR1 – 030. Welder is identified as 053742. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

FCAW process welding of weld joint #001 located on Traveler Rail 10TR2 – 020. Welder is identified as 066064. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

FCAW process welding of weld joint #002 located on Traveler Rail 11TR2 – 014. Welder is identified as 068858. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

FCAW process welding of weld joint #001 located on Traveler Rail 10TR1 – 012. Welder is identified as 215009.

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

BAY 6

This QA Inspector observed the following work in progress:

TOWER

SMAW process welding of weld joint #8B located on WD1 – A305 – 53M – 2. Welder is identified as 070007. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) FCM – Repair – 1.

SMAW process welding of weld joint #8A located on WD1 – A305 – 53M – 2. Welder is identified as 070007. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) FCM – Repair – 1.

Cross Beam – 8

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #065 located on Floor Beam FB204 – 017. Welder is identified as 053609. ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

FCAW process welding of weld joint #069 located on Floor Beam FB204 – 019. Welder is identified as 053609. ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

Cross Beam – 9

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #014 located on Cross Beam CB202G – 009. Welder is identified as 220688. ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
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Reviewed By:	Whitehead,Lonnie	QA Reviewer
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